

*301 mg*  
**Work Order ID 64693**

Tuesday, December 14, 2010 1:09:28 PM

Page 1

Item ID: D3049-1

Accept

Revision ID:

Item Name: Bearpaw

Start Date: 12/14/2010 Start Qty: 8.00

Required Date: 12/22/2010 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3049

Rev A1

110

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D3049-1\_BLANK

B10-12-21

(8)

120

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1  
3-Deburr

B10-12-21

SL 11/01/06

130

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

SL 11/01/06

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 64693

Tuesday, December 14, 2010 1:09:28 PM



Page 2

Item ID: D3049-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 12/14/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*and 11/01/07*

*8 8*

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

Packaging

*11/1/07 SP 82*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*OK 11/01/07*

*me*

*11-01-07*

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, December 14, 2010 1:09:33 PM

Page 1

Work Order ID: 64693

Parent Item: D3049-1

Parent Item Name: Bearpaw



Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 8.00

Required Qty: 8.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	219.5794	3.4	27.2			



UHMW 1" Black



1810-12-21

### Location

### Loc Qty

### Loc Code

MAT

219.5794

114624

5.2734

115325

15.506

115955

38.8

116281

160

116281

(8)

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	64493
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D3049-1
<b>Inspection Dwg:</b> D3049 <b>Rev:</b> A1		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	.260	✓		Vern J2-3	
B	0.93	+/-0.030	.925	✓		"	
C	0.40	+0.030/-0.000	.415	✓		"	
D	2.00	+/-0.030	1.998	✓		"	
E	10.250	+/-0.010	10.250	✓		Vern CVC-02	
F	4.540	+/-0.030	4.540	✓		"	
G	5.88	+/-0.030	5.881	✓		"	
H	0.38	+/-0.030	.378	✓		"	
I	11.50	+/-0.030	11.50	✓		"	
J	0.07 x 45°	+0.030/-0.010	.065x45°	✓		"	
K	0.44 - 0.47	+/-0.000	.460	✓		"	
L	R0.25	+/-0.030	.250	✓		R-G	
M	0.38	+/-0.010	.378	✓		"	
N	0.95	+0.030/-0.010	.948	✓		"	
O	0.69	+/-0.030	.693	✓		"	
P	0.20	+/-0.030	.199	✓		"	
Q	23.00	+/-0.030	23.00	✓		m-tape	
R	0.25 x 45°	+/-0.030	.260x45°	✓		"	

<b>Measured by:</b>	<i>[Signature]</i>
<b>Date:</b>	11/01/06

<b>Audited by:</b>	<i>[Signature]</i>
<b>Date:</b>	11/01/07

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue      P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

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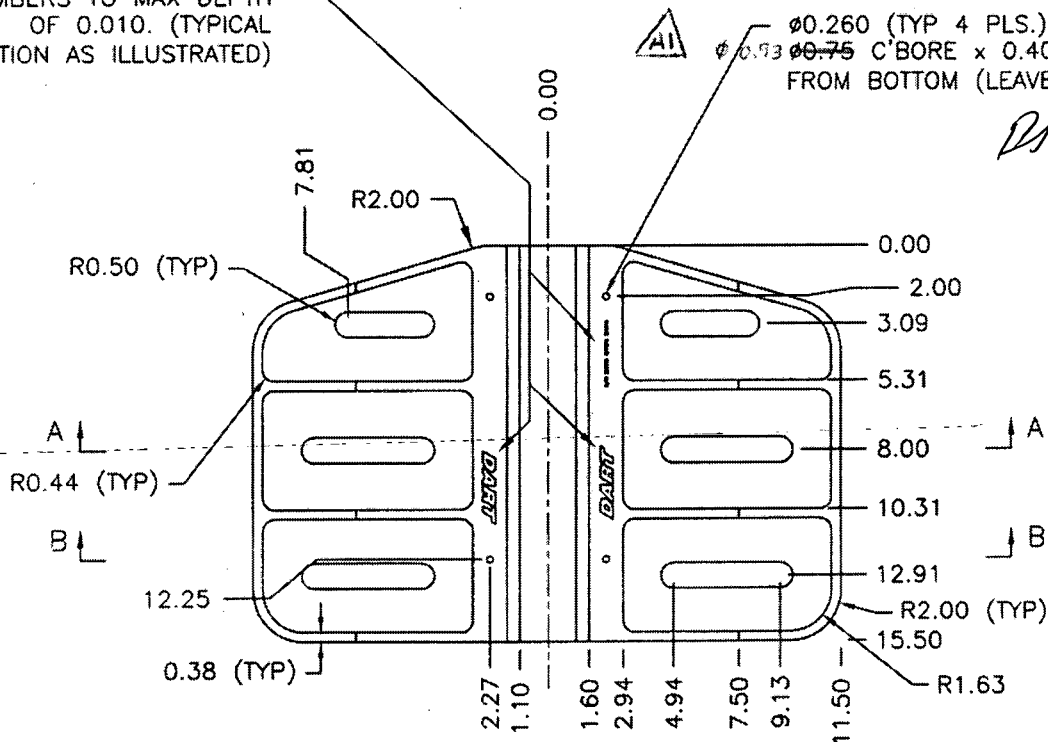


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18		TITLE BEARPAW	SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	# RF 03.01.13	Ø 0.93 WAS Ø 0.75	

RELEASED  
01.10.24

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 04693

ENGRAVE DART LOGO TO  
MAX DEPTH OF 0.012.  
ENGRAVE PART AND BATCH  
NUMBERS TO MAX DEPTH  
OF 0.010. (TYPICAL  
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

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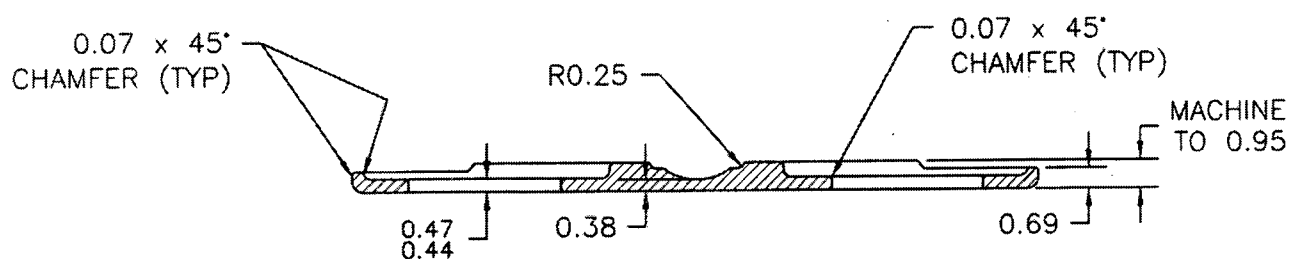
**NOTE:** Date & initial all entries



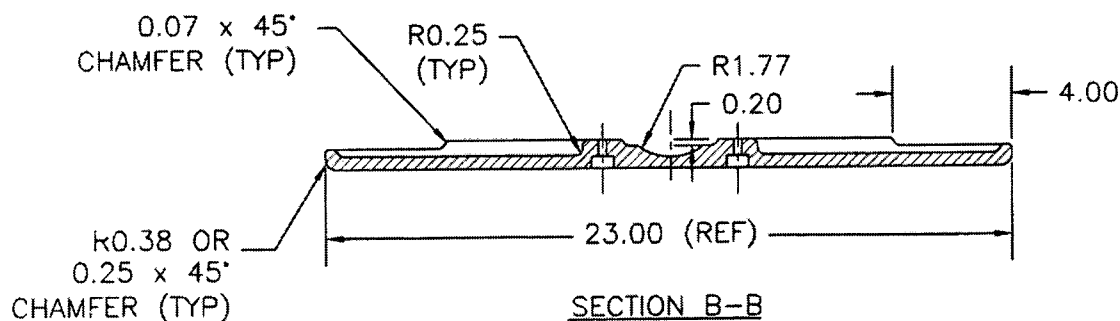
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED  
0.10.24 *[Signature]*

01064693



SECTION A-A



SECTION B-B

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